

ENGINEERING CHANGE NOTICE NO. 02866		SHEET 1 OF 1	
DWG NO. 647.4100	REV: N/C	PREPARED BY R. ROSANO	DATE: 05/05/10
DWG TITLE: SHEET METAL			
APPROVED BY: <i>[Signature]</i>	ENGR. <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER
TRANSACTION CODES (TC): A-ADD R-REVISE D-DELETE		REASON: CHANGED PRETREATMENT CALLOUT	

SHEET 1, ZONE A1 IS:

NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4

2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE II, CLASS 2, COULDER BLACK;  
PRETREAT PR-148 ADHESION PROMOTER  
PRIME IAW MIL-P-23377J TYPE I CLASS N

IS

3. DEBURR AND BREAK ALL SHARP EDGES

4. IDENTIFY IAW MPP-120

Superseded

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:						
				<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BOM <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

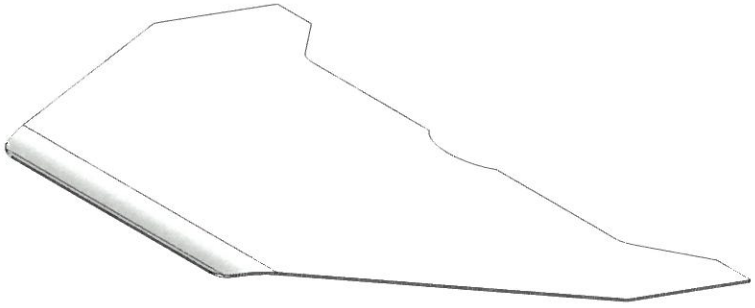
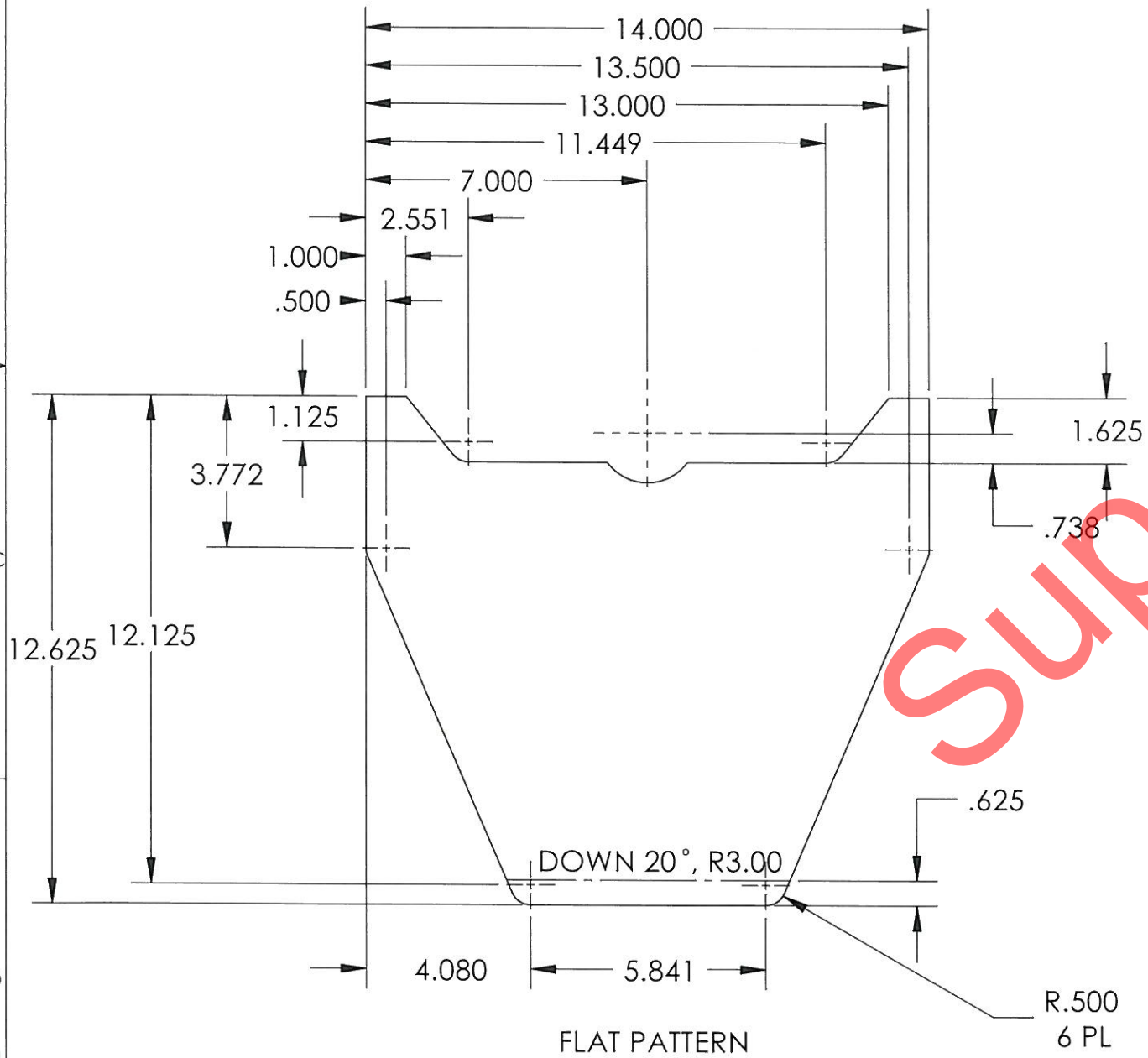
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REVISIONS

REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE RELEASE PP1		N/C
N/C	INITIAL RELEASE	08/25/09	P. BRAVO

NOTES: UNLESS OTHERWISE SPECIFIED
















1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE II,  
CLASS 2, COLOR BLACK;  
CARDINAL 4860-50 PRETREATMENT PRIMER  
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.4110

UNINCORPORATED ECN(s)

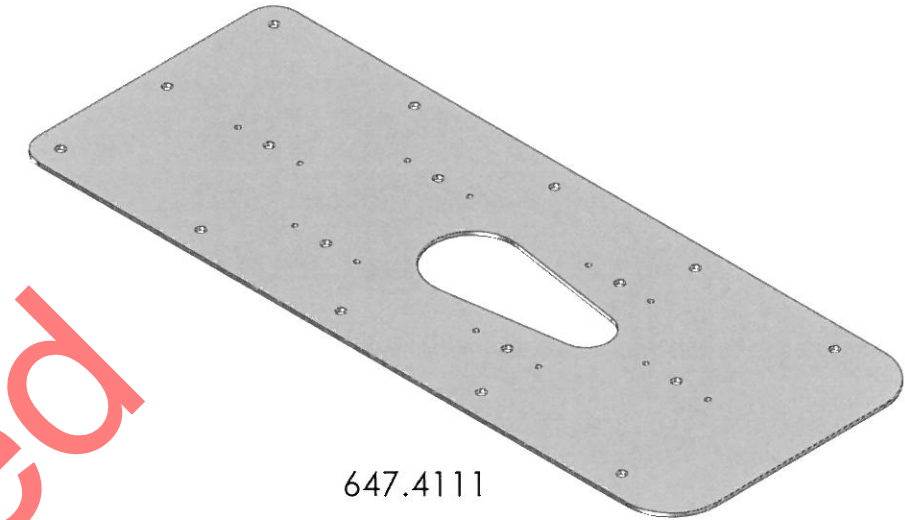
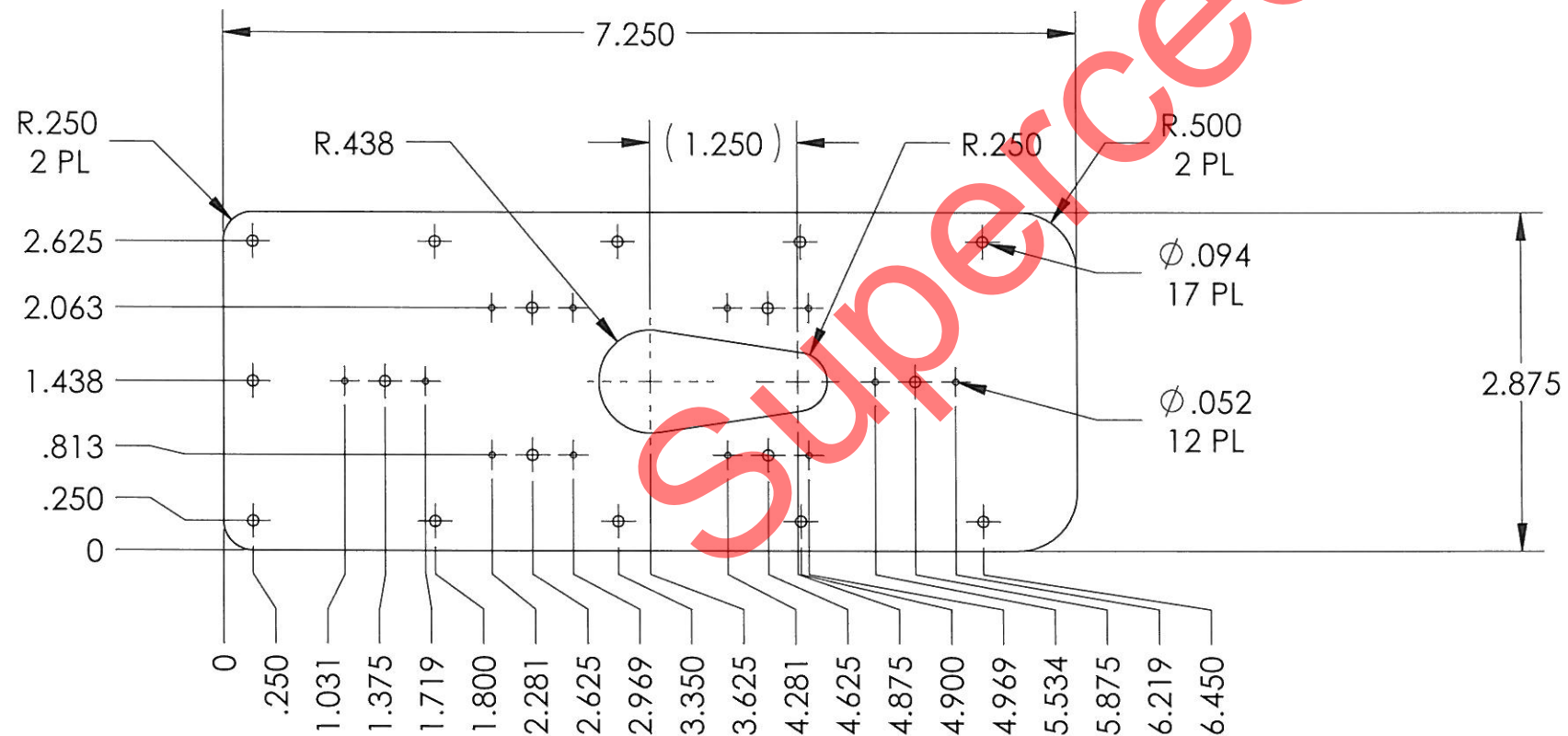
028666

			647.4116	SHIM		
			647.4115	SHIM		
			647.4114	SHIM		
			647.4113	CLIP		
			647.4112	CLIP		
			647.4111	DOUBLER		
			647.4110	DOUBLER		
		FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY		PARTS LIST				
NEXT ASSY (S)		ORIGINAL DATE (MO-DA-YR) 08/25/09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
647.3700		DRAWN BY P. ROSANO				
		CHECKER D. BARKER				
		DRAWING APPROVAL P. BRAVO 08/25/09 				
		CONTRACT NO.		SHEETMETAL		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°				
		SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.4100	REV. N/C	
SCALE NONE				SHEET 1 OF 6		

1 2 3 4 5 6 7 8

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TYP.



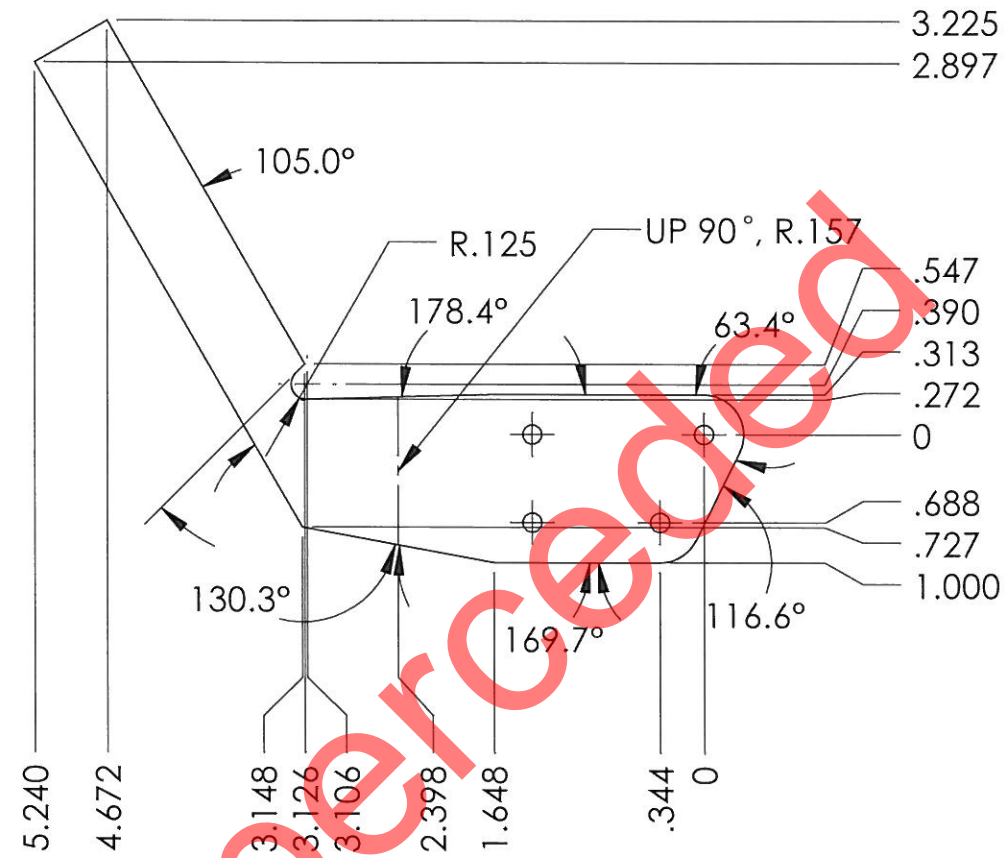
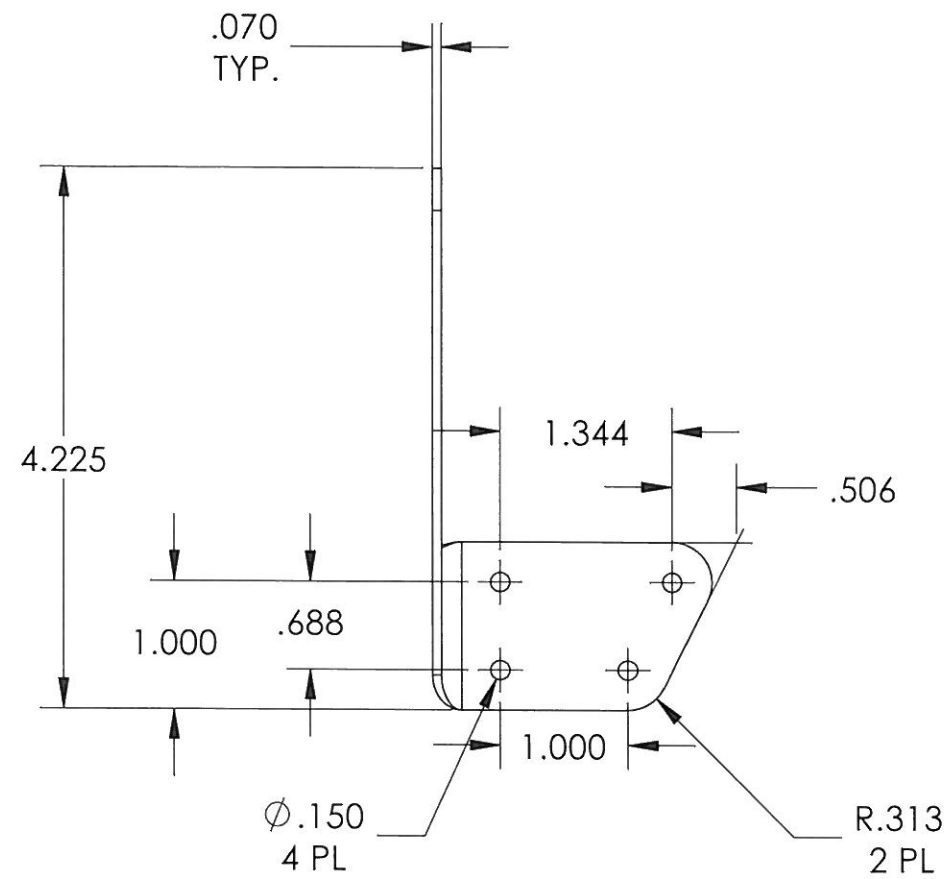
647.4111

ORIGINAL DATE (MO-DA-YR) 08/25/09		APICAL INDUSTRIES	
DRAWN BY P. ROSANO	CHECKER D. BARKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO 08/25/09		SHEETMETAL	
CONTRACT NO.		SIZE B	REV. N/C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm 5^\circ$		CAGE CODE 07MZ6	DWG. NO. 647.4100
		SCALE NONE	SHEET 2 OF 6

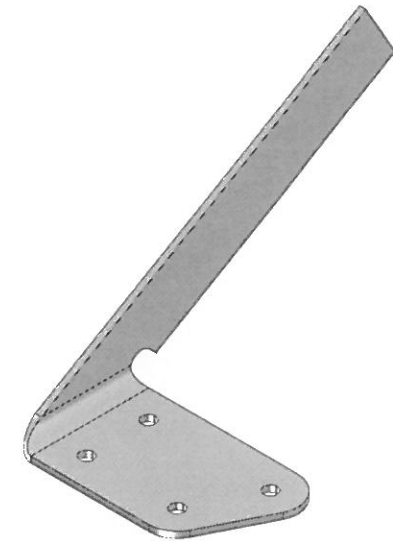
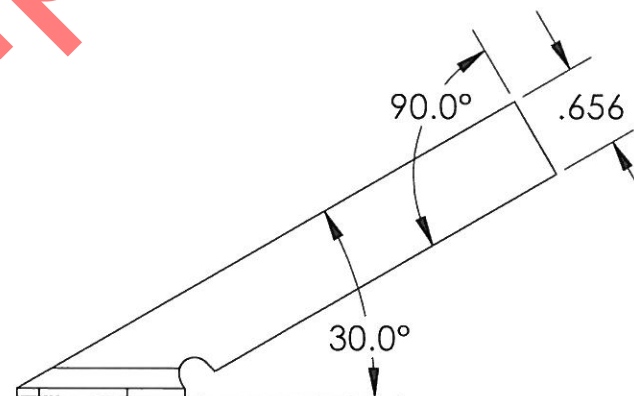


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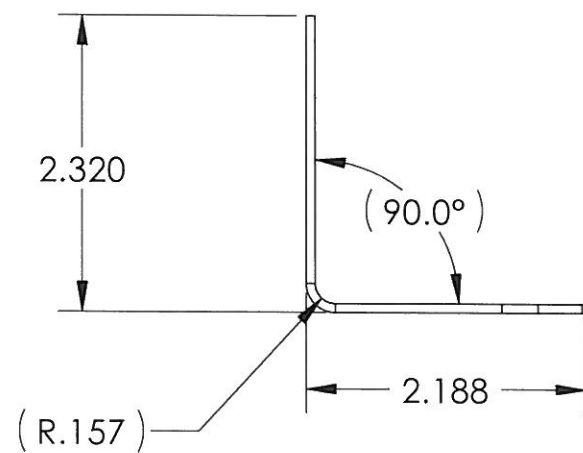
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



FLAT PATTERN



647.4113 SHOWN  
647.4112 OPPOSITE



ORIGINAL DATE (MO-DA-YR) 08/25/09	DRAWN BY R. ROSANO	CHECKER D. BARKER	DRAWING APPROVAL P. BRAVO	CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± 5°	SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.4100	REV. N/C	SHEETMETAL
SCALE NONE	SHEET	3 OF 6			

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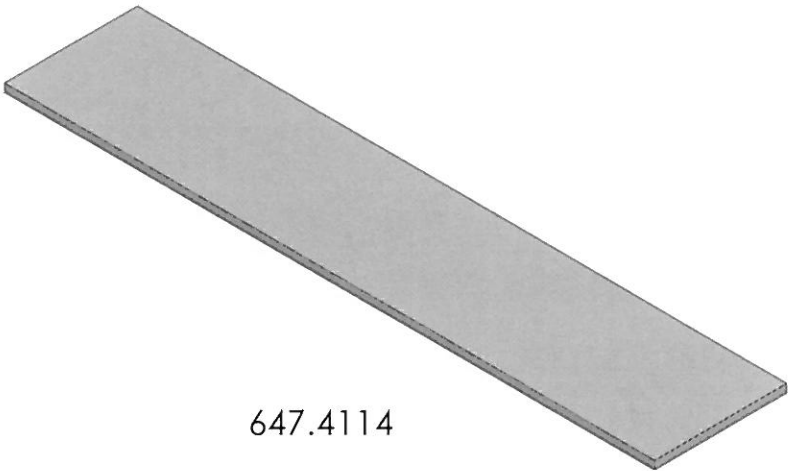
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4.80

.984

647.4114

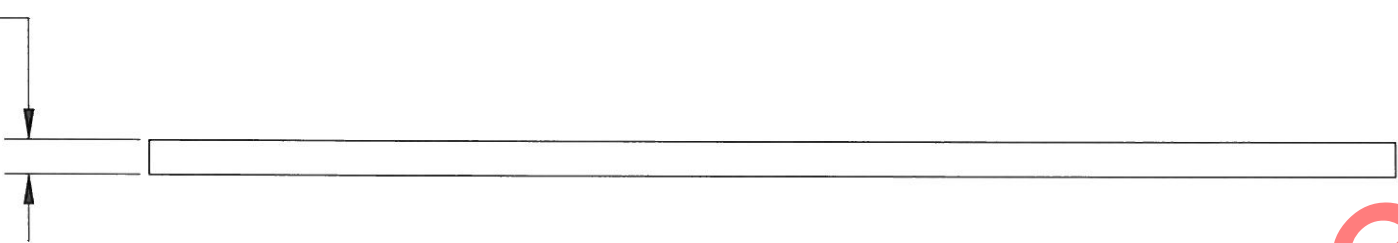


ORIGINAL DATE (MO-DA-YR) 08/25/09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY P. ROSANO	CHECKER D. BARTER		
DRAWING APPROVAL P. BRAVO 08/25/09		SHEETMETAL	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SIZE B	REV. N/C
		CAGE CODE 07MZ6	DWG. NO. 647.4100
SCALE NONE		SHEET 4 OF 6	

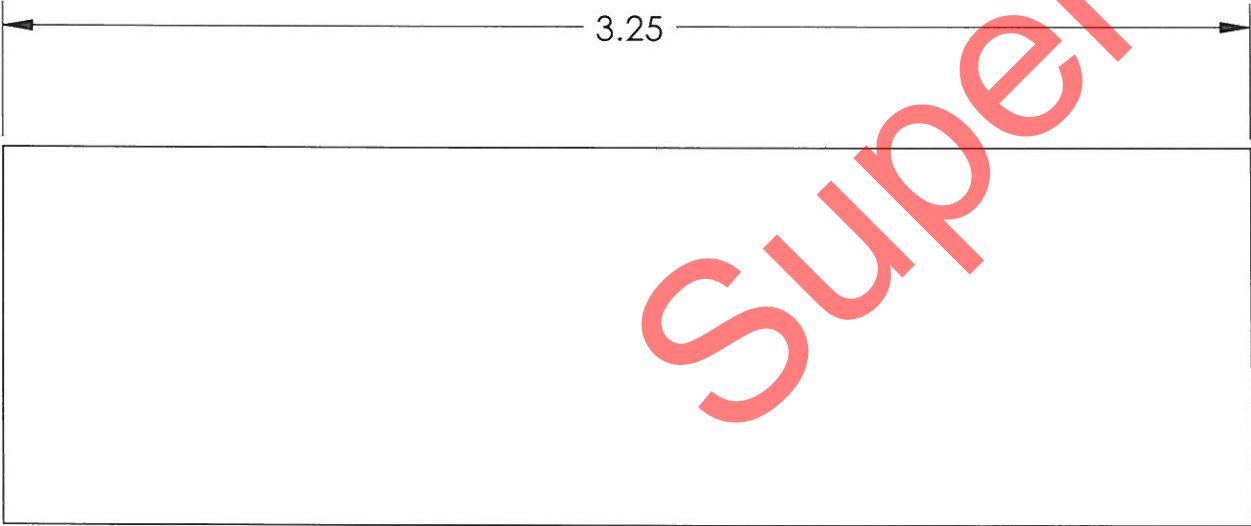
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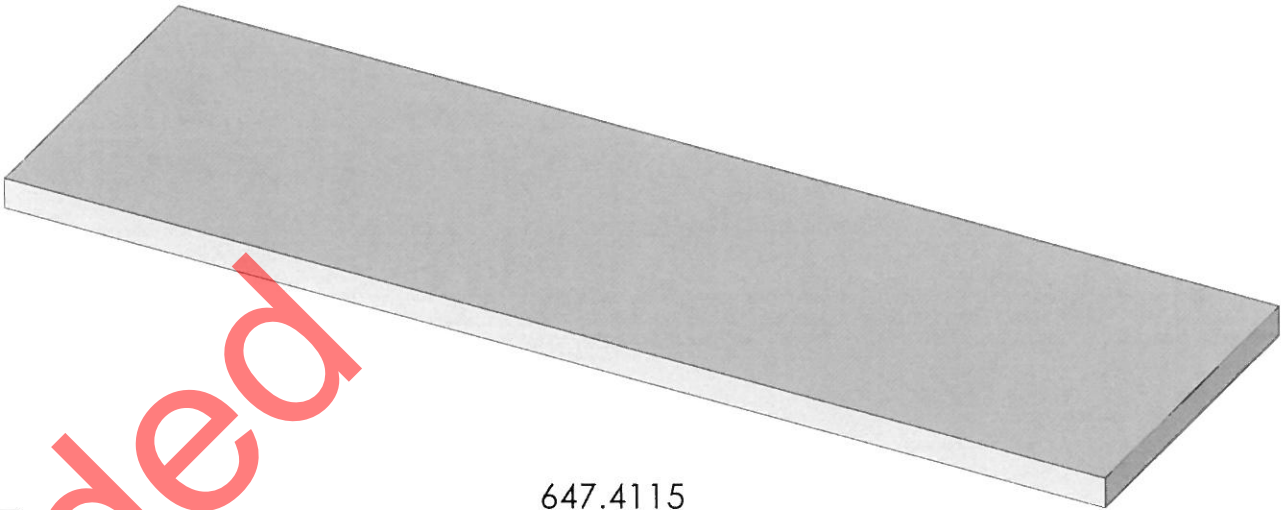
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3.25



.984



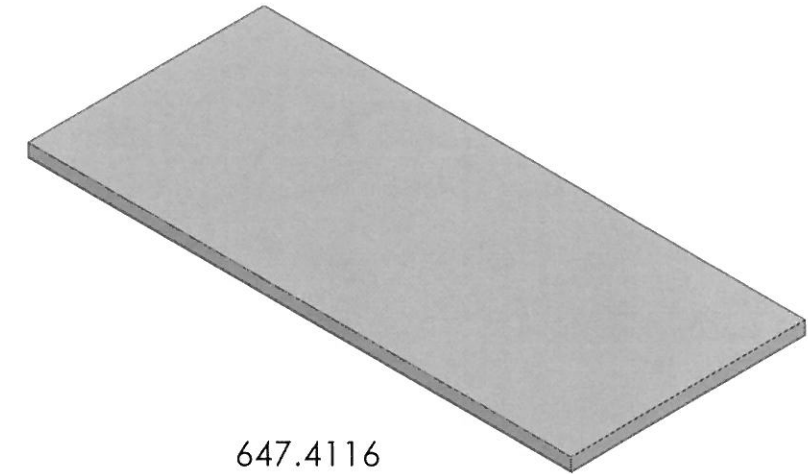
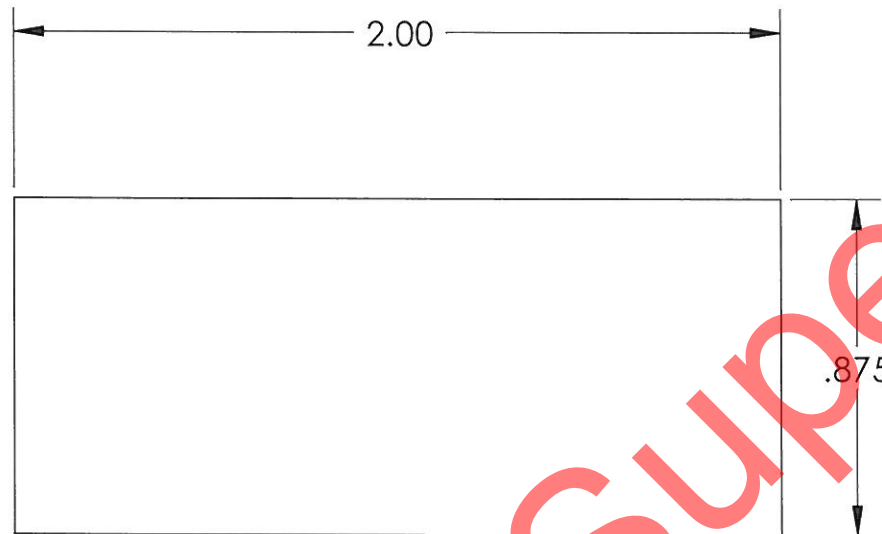
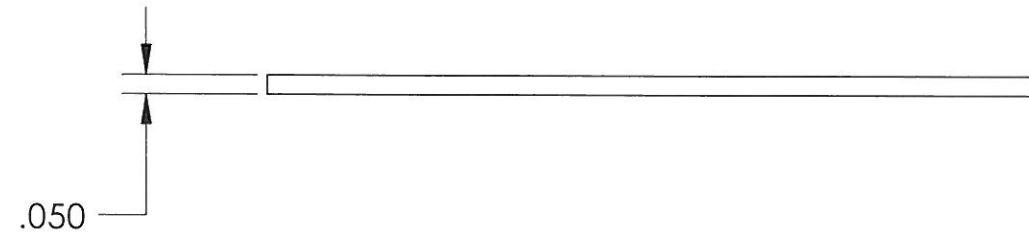
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ORIGINAL DATE (MO-DA-YR) 08/25/09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY P. POSANO	CHECKER D. BARKER		
DRAWING APPROVAL P. BRAVO 08/25/09		SHEETMETAL	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± 5°		SIZE B	REV. N/C
		CAGE CODE 07MZ6	DWG. NO 647.4100
SCALE NONE		SHEET 5 OF 6	

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		CAGE CODE 07MZ6	DWG. NO. 647.4100
SCALE NONE		SHEET 6 OF 6	